


REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	4/28/2017	SM	JAG

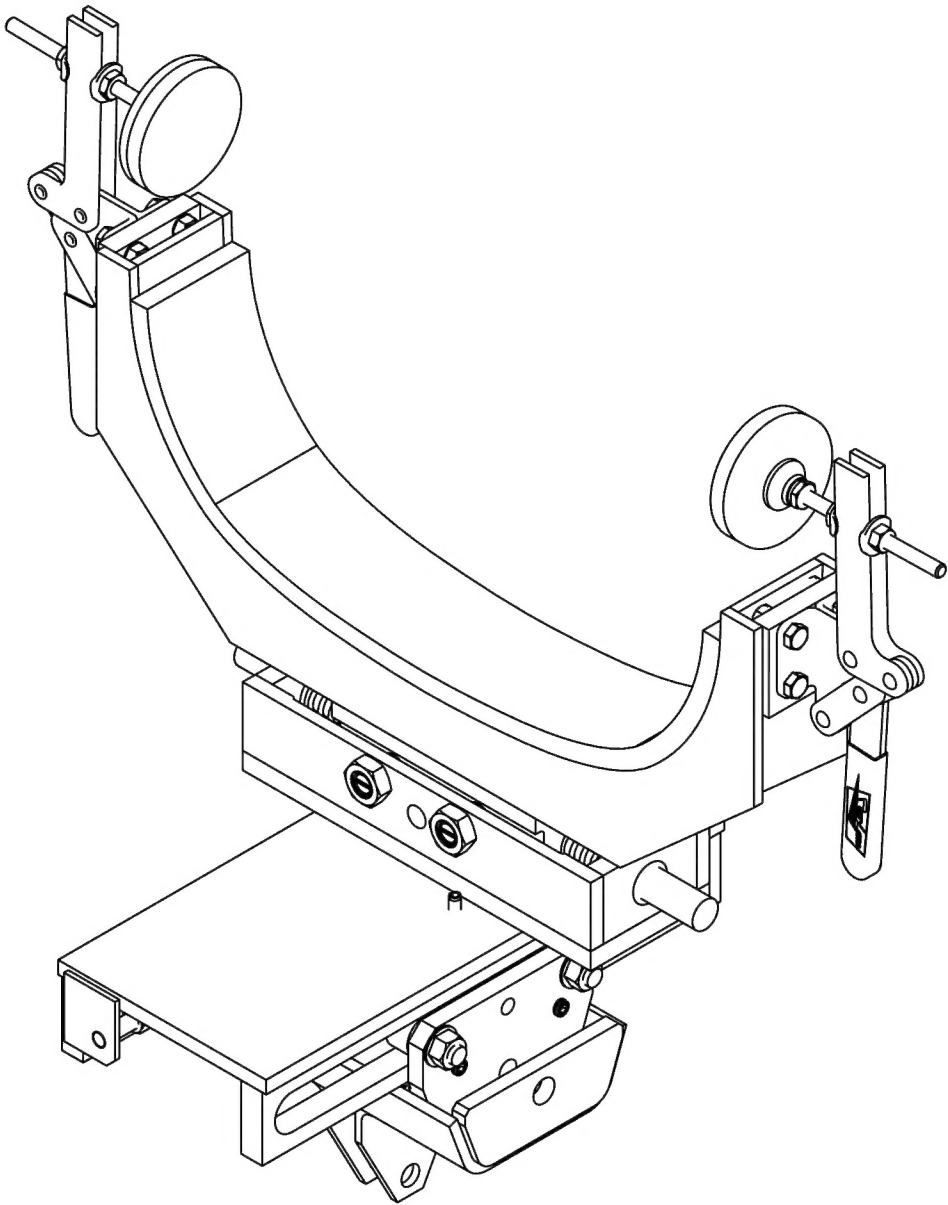


			
TITLE			
SUPPORT DOLLY, TAILBOOM			
DWG NO.			REV
RB T102012-15			1
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT		DIMENSIONS ARE IN INCHES	
TREAT		.XXX ± .005 FRACTIONS ± 1/8	
FINISH		.XX ± .01 ANGLES ± 5°	
SPEC		.X ± .1 SURFACES = 125/✓	
DRAWN BY:		1. BREAK ALL SHARP EDGES	
GILBERT		.015 x 45° OR .015R	
CHECKED:		2. DIMENSIONAL LIMITS APPLY	
CLOUGH		AFTER PLATING	
DPPS APPR:		3. INTERPRET DIM AND TOL PER	
ANDERSON		ASME Y14.5M-2009	
QA APPR:		USED ON MODEL	
LINDSAY		BELL 212, 214B, 214ST, 412	
APPROVED:		GILBERT	
SCALE	1:4	DATE	3/13/2014
		SHEET 1 OF 32	

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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED

ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				X		-131	1	CRADLE WELDMENT			3
				2		-133		CRADLE	A36/1018/1020 HR		4
				1		-135		CRADLE FACE	A36/1018/1020 HR		5
				2		-137		CRADLE END PLATE	A36/1018/1020 HR		6
				1		-139		TOW END CRADLE, PIVOT	A36/1018/1020 HR		7
			X			-141	1	BOX WELDMENT			8
			1			-143		BOX BOTTOM	A36/1018/1020 HR		9
			2			-145		BOX FRONT	A36/1018/1020 HR		10
			2			-147		BOX END	A36/1018/1020 HR		11
			1			-149		STUD	A36/1018/1020 HR		12
		X				-151	1	SLIDE WELDMENT			13
		1				-153		SLIDE TOP	A36/1018/1020 HR		14
		1				-155		SLIDE SIDE	A36/1018/1020 HR		15
		1				-157		SLIDE SIDE-BOLTED	A36/1018/1020 HR		16
		1				-159		SLIDE SPRING ROD SUPPORT	A36/1018/1020 HR		17
						-161	1	SLIDE SPRING ROD SUPPORT, BOLTED	A36/1018/1020 HR		18
	X					-163	1	CUP WELDMENT			19
	1					-165		CUP	1018/1020 CR		20
	2					-167		CUP, END	A36/1018/1020 HR		21
	1					-169		CUP CENTER	A36/1018/1020 HR		22
	2					-171		CUP, MID	A36/1018/1020 HR		23
						-173	1	CRADLE ROD	4140 G&P		24
						-175	1	SPRING ROD	303 S.S.		25
						-177	1	ROD SUPPORT	A36/1018/1020 HR		26
						-179	1	FLANGE BEARING	BRONZE	Ø1-5/8 I.D. SYMCO #SF-5264-32 (MODIFIED)	27
						-181	2	PIVOT BRACKET	A36/1018/1020 HR		28
						-183	2	RUBBER PAD	RUBBER	20A-40A DUROMETER RATING	29
X						-185	2	REST WELDMENT			30
1						-187		REST WELDMENT PAD	A36/1018/1020 HR		31
1					B/O	-189		LEVELING STUD	STEEL	CARR LANE # CL-5-SLF-4	30
					B/O	-191	1	CRADLE PAD	17124	1/2 X 3 X 24	32
					B/O	-193	14	HEX HEAD CAP SCREW	STEEL	5/16-18 X 1 (MCMASTER-CARR #92865A583)	1
					B/O	-195	14	HEX NUT	STEEL	5/16-18 (MCMASTER-CARR #95462A030)	1
					B/O	-197	14	WASHER	STEEL	Ø5/16 (MCMASTER-CARR #95229A450)	1
					B/O	-199	4	SET SCREW	STEEL	3/8-16 X 5/8 (MCMASTER-CARR #94105A613)	1
					B/O	-201	4	HEX NUT	STEEL	7/16-20 (MCMASTER-CARR #95462A520)	1
					B/O	-203	8	WASHER	STEEL	Ø7/16 (MCMASTER-CARR #90126A032)	1
					B/O	-205	4	TRACK ROLLER	STEEL	Ø1 X 5/8 (MCMASTER-CARR #1460T17)	1
					B/O	-207	2	COMPRESSION SPRING	STEEL	Ø.092 X Ø3/4 O.D. X 5 (MCMASTER-CARR #9657K215)	1
					B/O	-209	2	SLOTTED SPRING PIN	STEEL	Ø1/4 X 3/4 (MCMASTER-CARR #90692A740)	1
					B/O	-211	1	SLOTTED HEX NUT	STEEL	1-1/4 -12 (MCMASTER-CARR #95030A360)	1
					B/O	-213	1	THRUST CAGE ASSEMBLY	STEEL	2-3/4 O.D. (MCMASTER-CARR #5909K43)	1
					B/O	-215	2	THRUST WASHER	STEEL	Ø2-3/4 O.D. (MCMASTER-CARR #5909K56)	1
					B/O	-217	4	HEX NUT	STEEL	5/8-11 (MCMASTER-CARR #94846A533)	1
					B/O	-219	4	BALL-NOSE SPRING PLUNGER	STEEL	5/8-11 X .984 (MCMASTER-CARR #3408A124)	1
					B/O	-221	2	COMPRESSION SPRING	STEEL	Ø.105 X Ø.97 O.D. X 3-1/2 (MCMASTER-CARR #9657K455)	1
					B/O	-223	1	SLOTTED SPRING PIN	STEEL	Ø1/4 X 2 (MCMASTER-CARR #90692A749)	1
					B/O	-225	2	FLANGE BEARING	BRONZE	SYMCO #SF-2432-10	1
					B/O	-227	2	TOGGLE CLAMP	STEEL	CARR-LANE #CL-351-TC	1
					B/O	-229	4	FLANGED WASHERS	TEMPERED SPRING STEEL	CARR-LANE #CL-51610-TW	1
					B/O	-231	1	COTTER PIN	STEEL	Ø3/16 X 3 (MCMASTER-CARR #98338A290)	1
					B/O	-233	5	HEX NUT	STEEL	3/8-24 MCMASTER-CARR #95462A515	1
-185 ASSY	-163 ASSY	-151 ASSY	-141 ASSY	-131 ASSY							

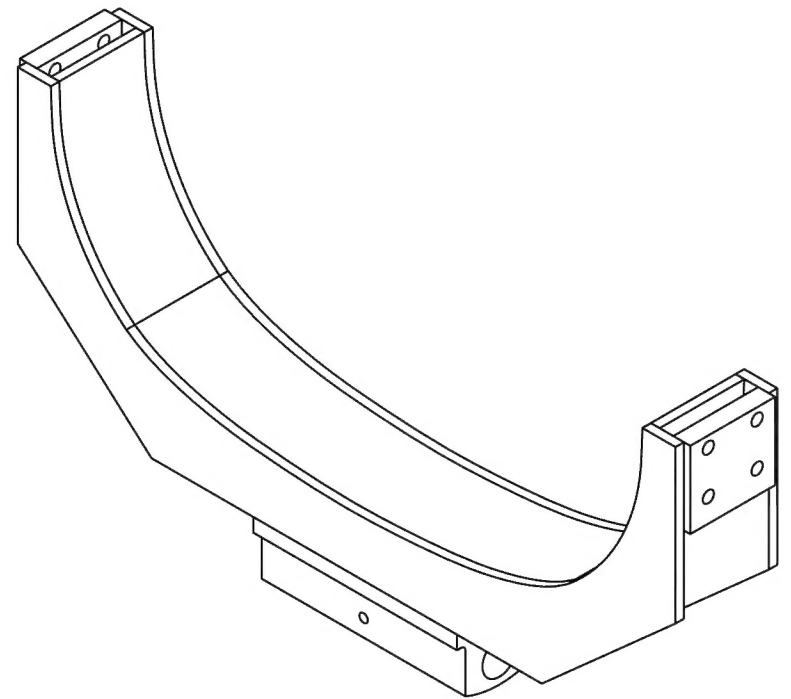
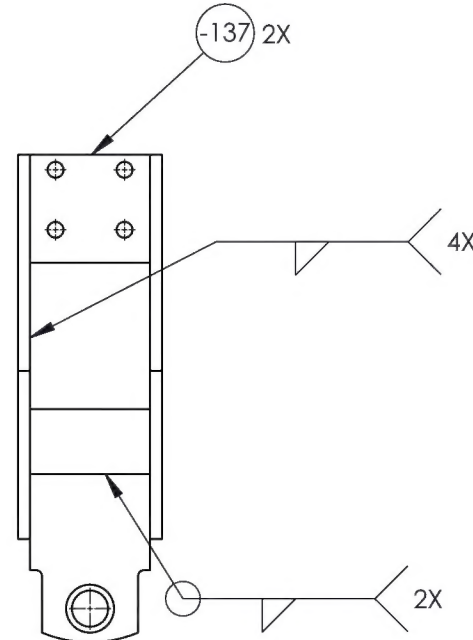
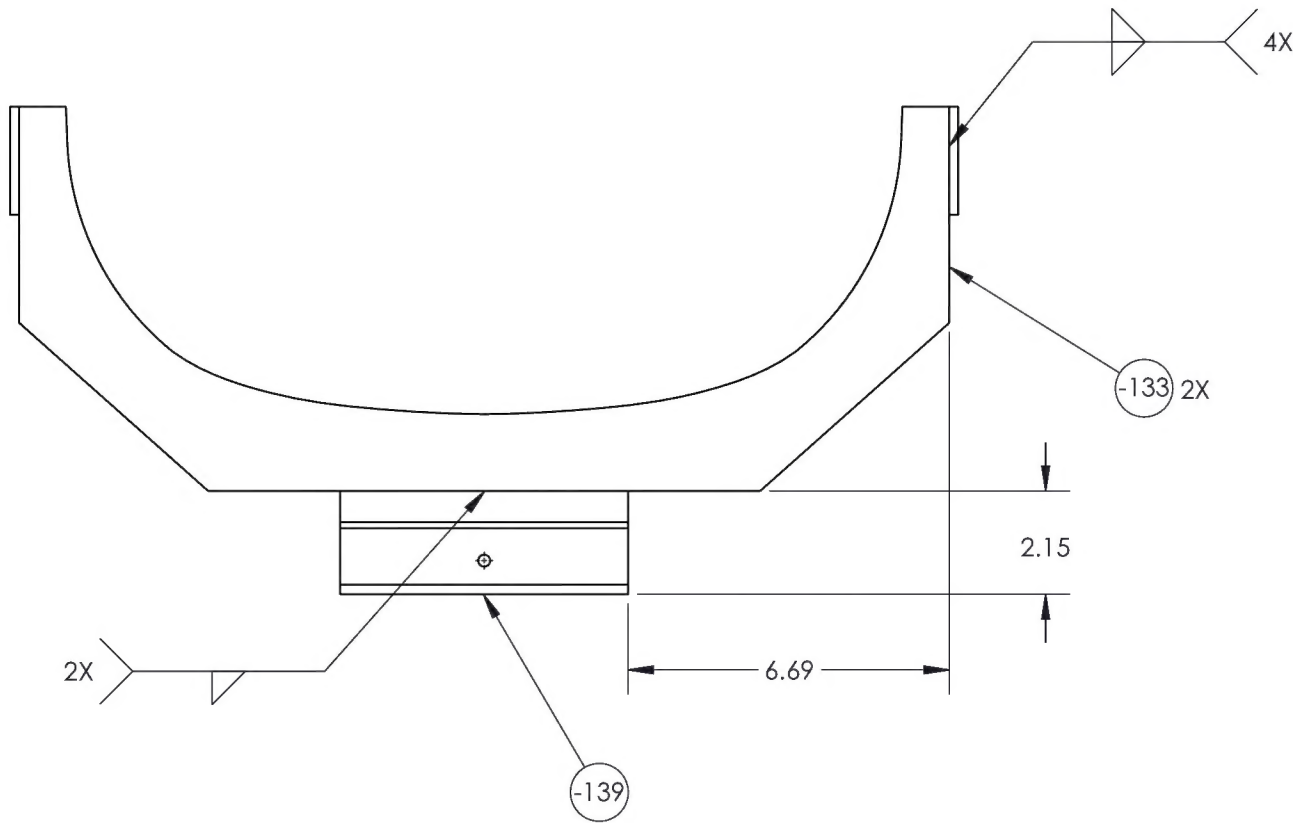
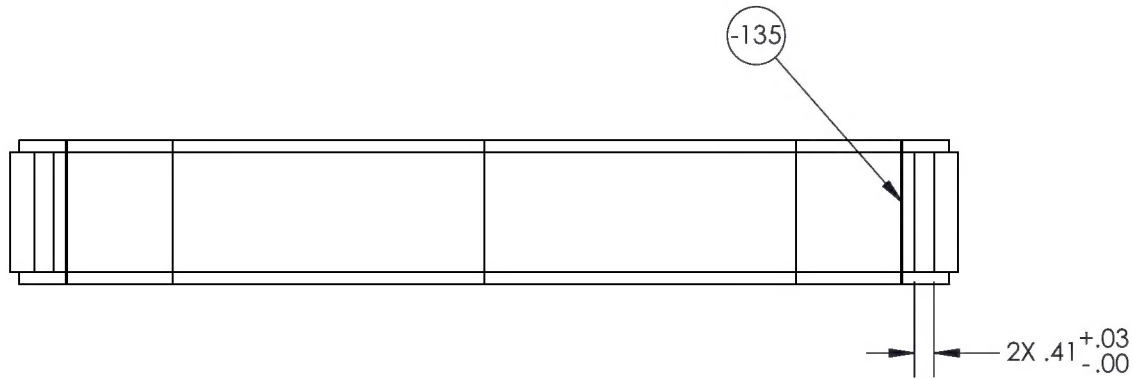


15
TOW SIDE LIFT

DART AEROSPACE			
TITLE SUPPORT DOLLY, TAILBOOM			
DWG NO. RB T102012-15			REV 1
MAT'L HEAT TREAT FINISH SPEC		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓	
DRAWN BY: GILBERT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: CLOUGH		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT		BELL 212, 214B, 214ST, 412	
SCALE 1:4	DATE 3/13/2014	SHEET 2 OF 32	

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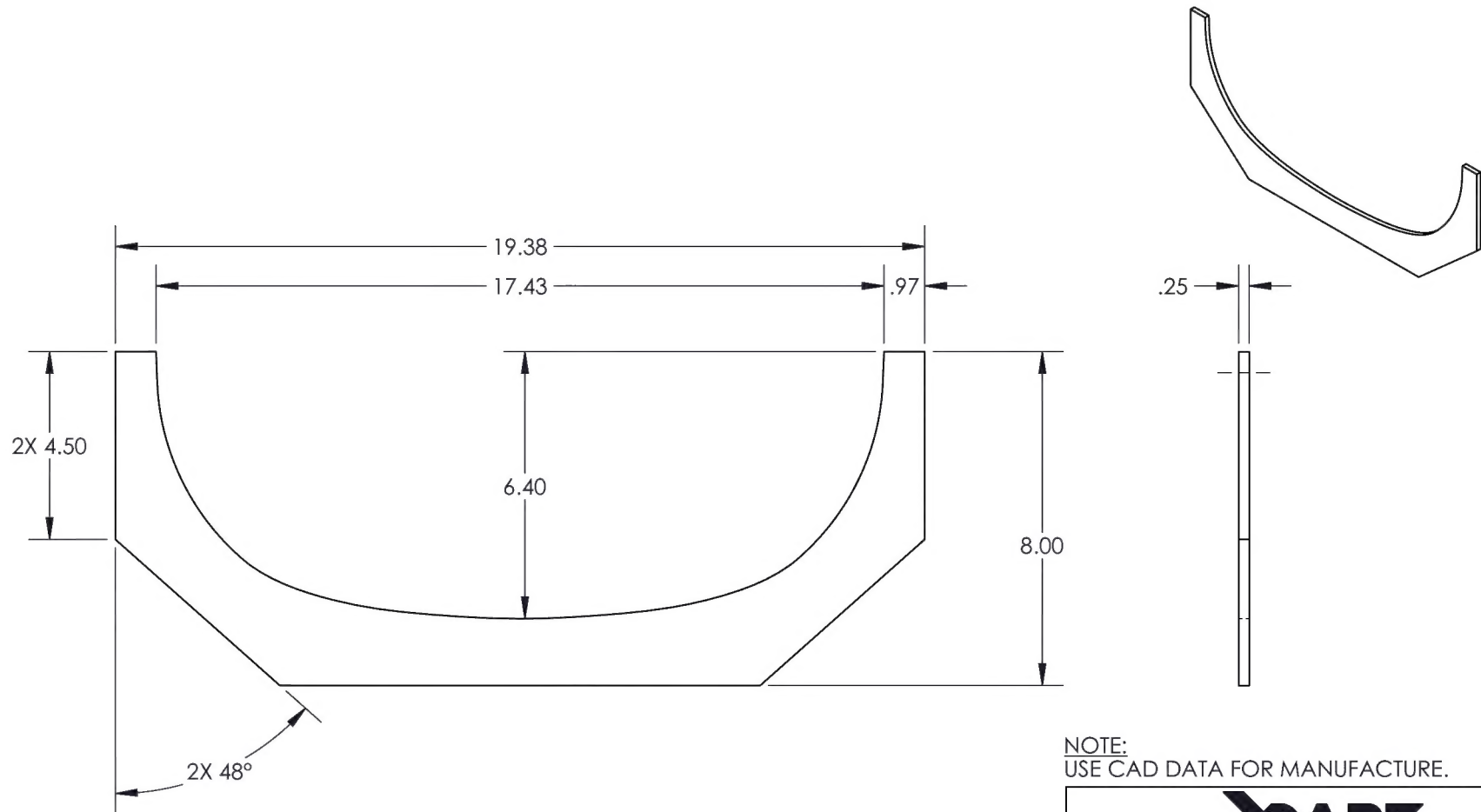
CRADLE WELDMENT

NOTE:
NO POWDER COAT IN HOLES.

DART AEROSPACE			
TITLE SUPPORT DOLLY, TAILBOOM			
DWG NO. RB T102012-131			REV 1
MAT'L HEAT TREAT FINISH POWDER COAT YELLOW SPEC FED #13538		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°	
DRAWN BY: GILBERT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: CLOUGH		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT		BELL 212, 214B, 214ST, 412	
SCALE 1:4	DATE 3/13/2014	SHEET 3 OF 32	

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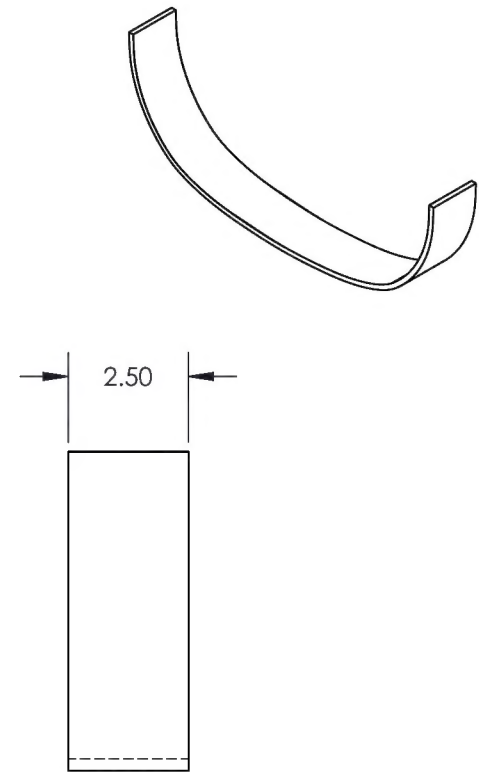
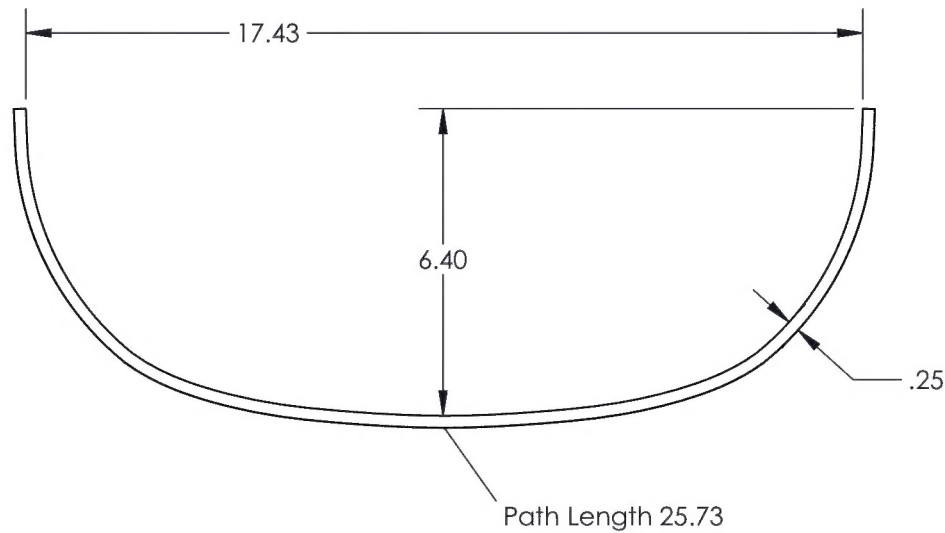
NOTE:
USE CAD DATA FOR MANUFACTURE.

(-133)
CRADLE

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-133	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -131 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:4	DATE 3/13/2014
	SHEET 4 OF 32

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				APPROVED



NOTE:
FIT TO WELDMENT.

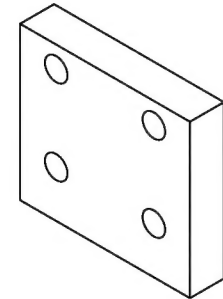
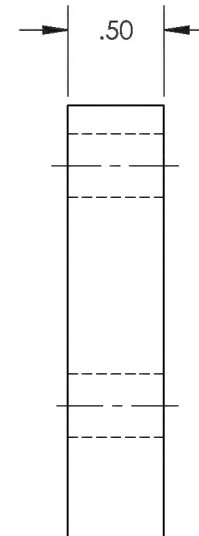
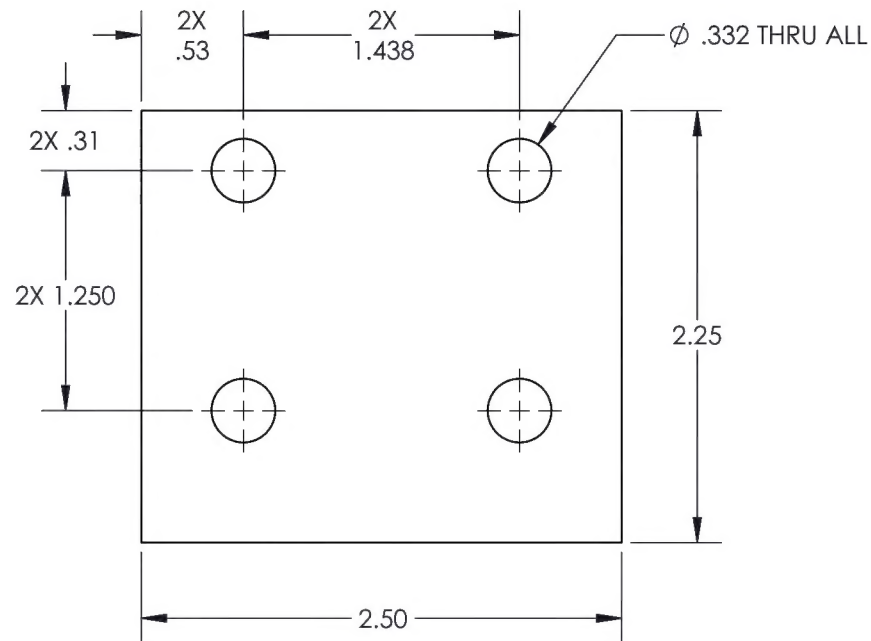
-135

CRADLE FACE

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-135	REV 1
MAT'L A36/1018/1020 HR FINISH SEE -131 WELDMENT SPEC DRAWN BY: GILBERT CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL BELL 212, 214B, 214ST, 412	
SCALE 1:4	DATE 3/13/2014
SHEET 5 OF 32	

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



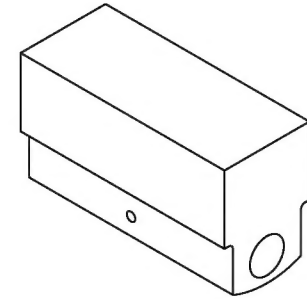
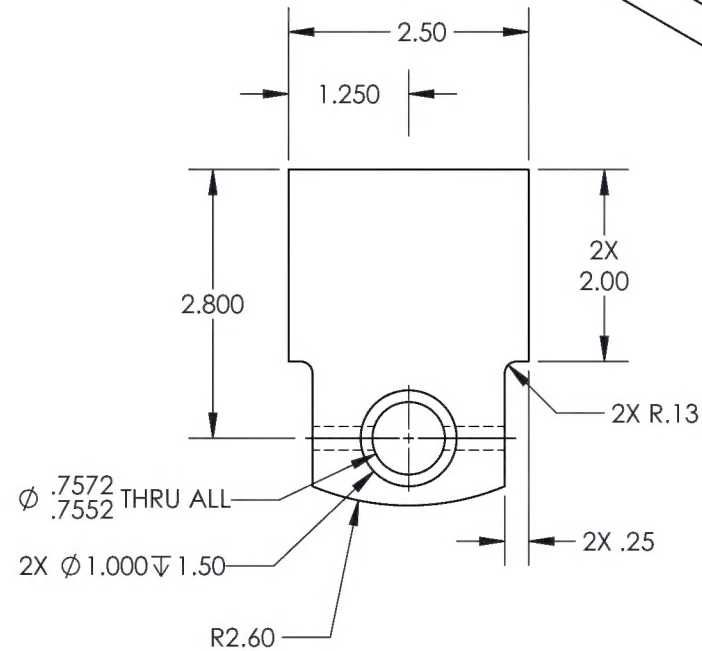
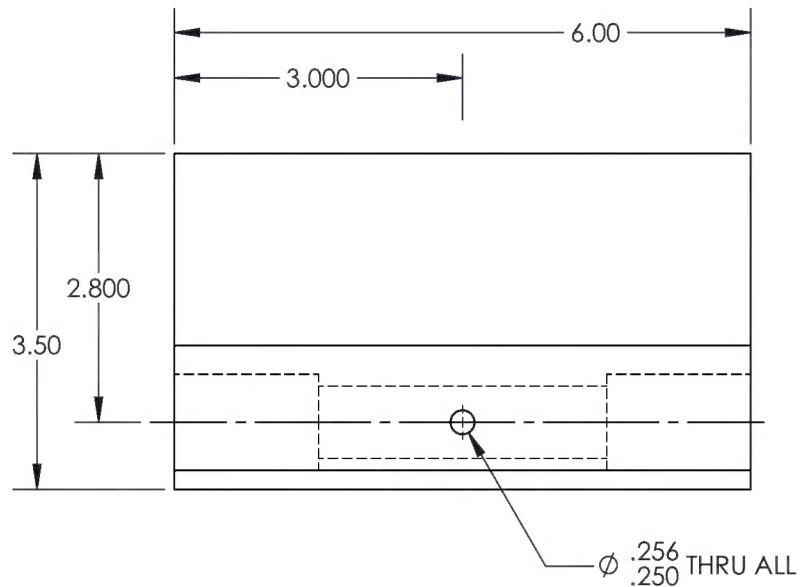
(-137)

CRADLE END PLATE

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-137	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -131 WELDMENT	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 3/13/2014
	SHEET 6 OF 32

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				APPROVED



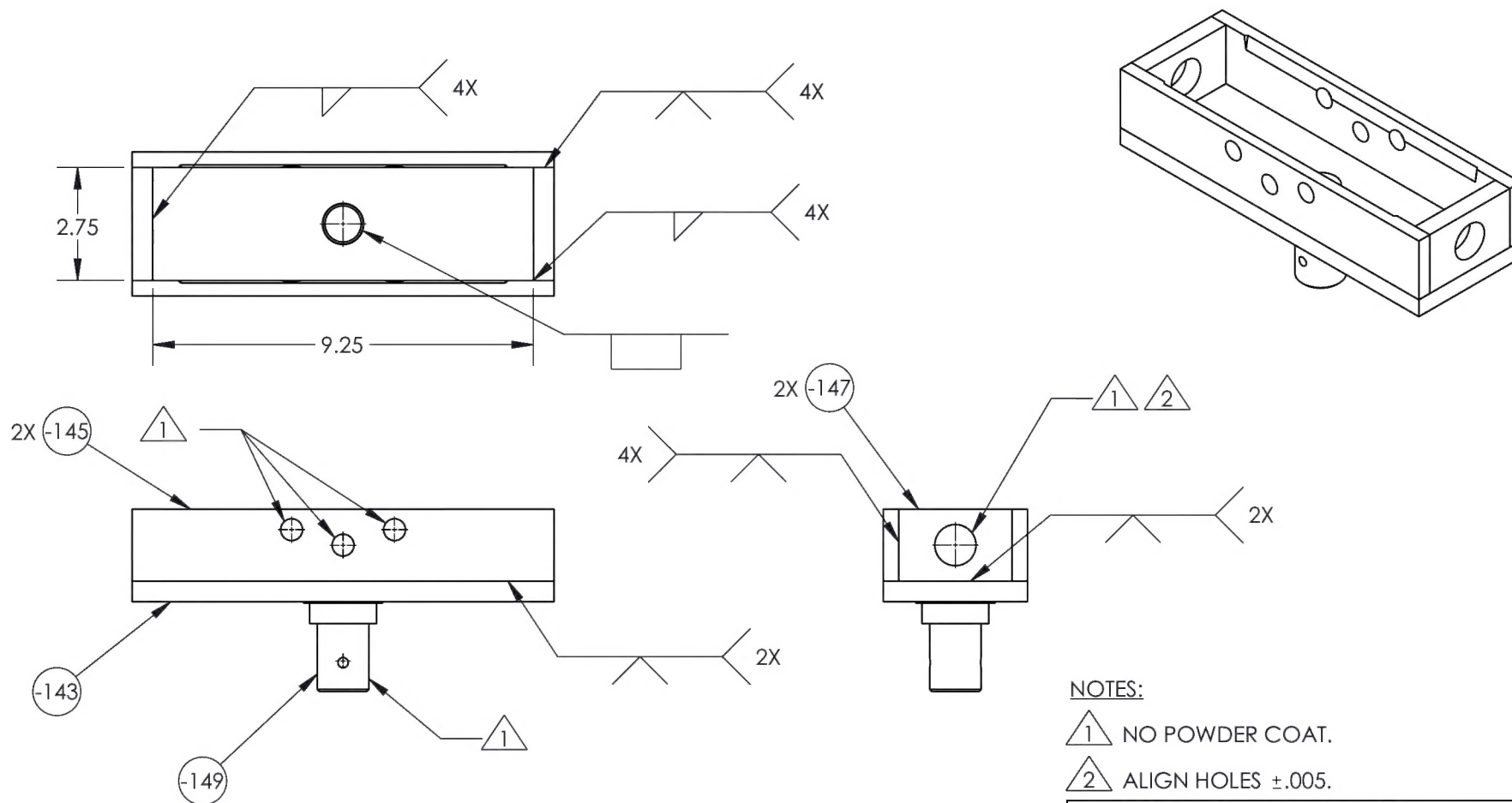
-139

TOW END CRADLE, PIVOT

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-139	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -131 WELDMENT	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 3/13/2014
	SHEET 7 OF 32

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				APPROVED



NOTES:

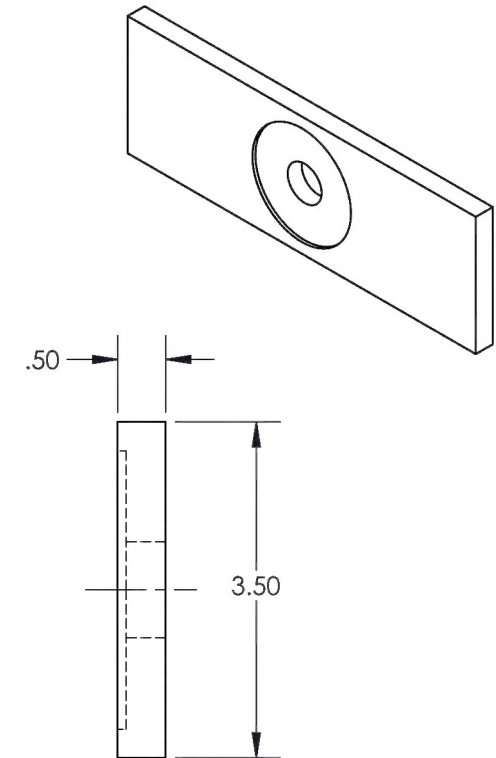
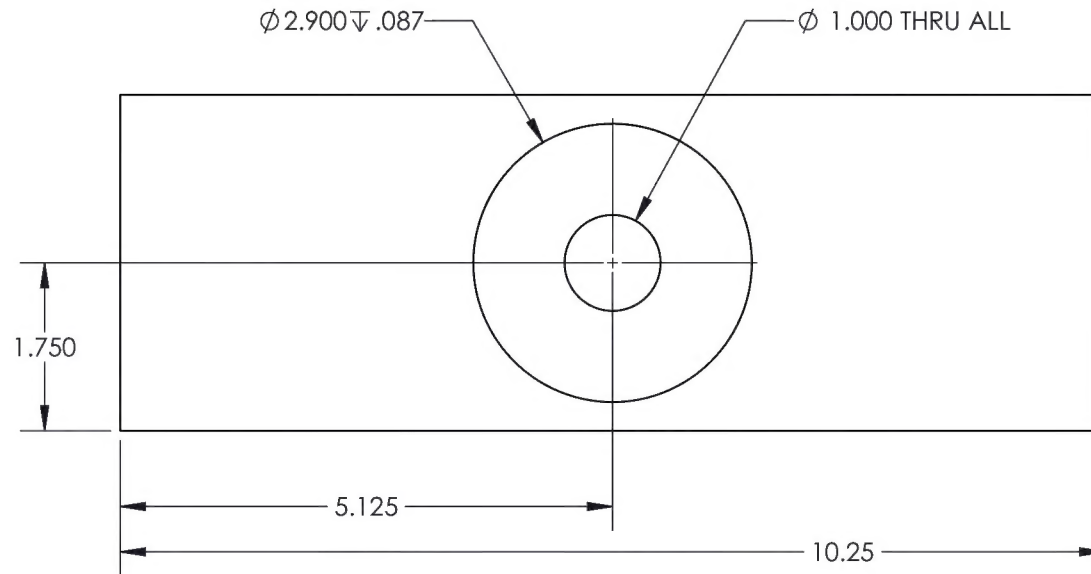
- NO POWDER COAT.
- ALIGN HOLES $\pm .005$.

DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	RB T102012-141
	REV 1
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX \pm .010 FRACTIONS \pm 1/8
SPEC	.XX \pm .03 ANGLES \pm 1°
	.X \pm .1 SURFACES = 125°
DRAWN BY:	GILBERT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
SCALE	1:4
DATE	3/13/2014
SHEET 8 OF 32	

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BOX WELDMENT

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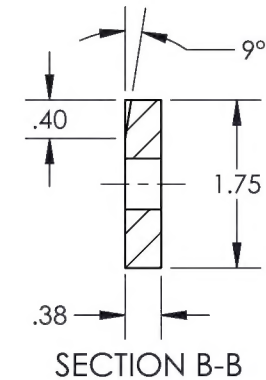
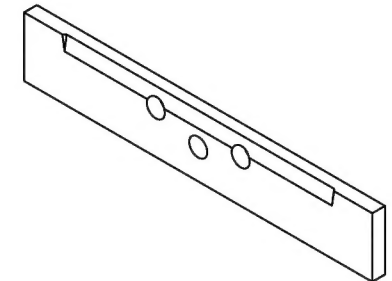
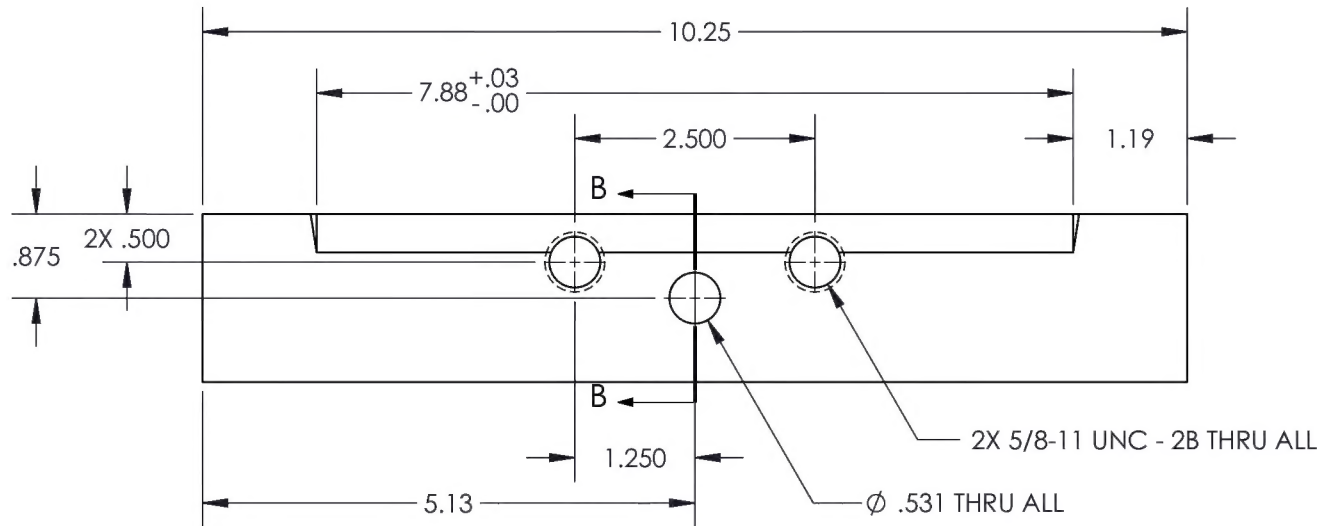
-143

BOX BOTTOM

TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-143	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -141 WELDMENT	.XXX \pm .010 FRACTIONS \pm 1/8
SPEC	.XX \pm .03 ANGLES \pm 1°
	.X \pm .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 3/13/2014
	SHEET 9 OF 32

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				APPROVED

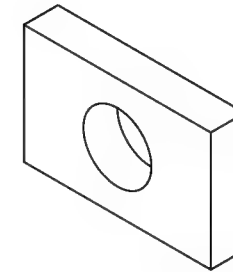
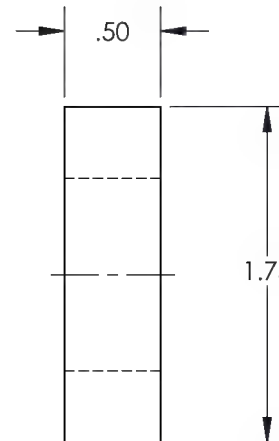
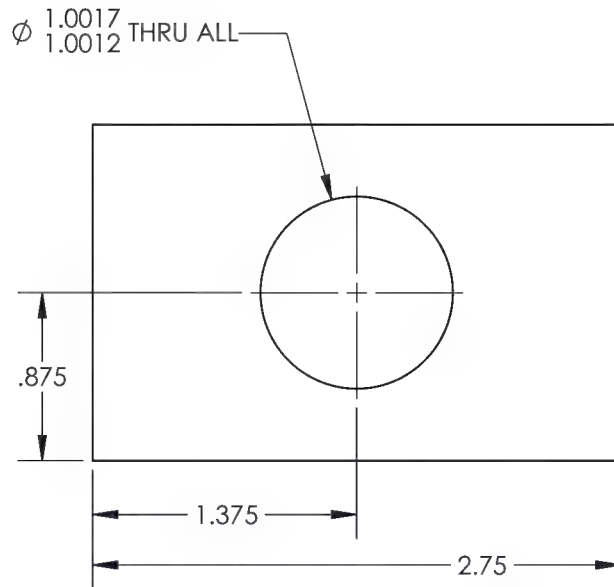


(-145)
BOX FRONT

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-145	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -141 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 3/13/2014
	SHEET 10 OF 32

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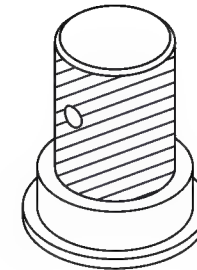
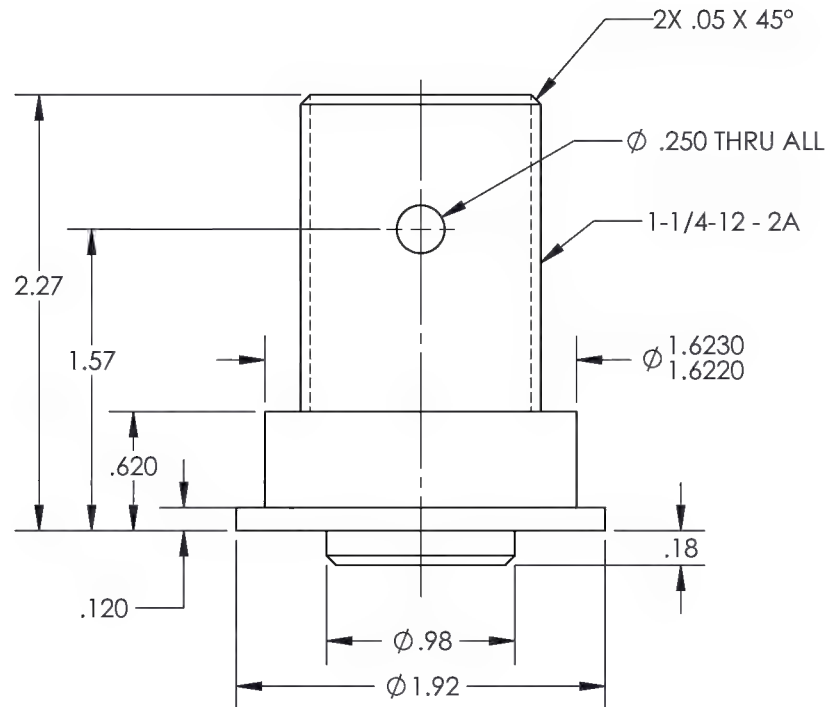


-147
BOX END

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-147	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -141 WELDMENT	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 3/13/2014
	SHEET 11 OF 32

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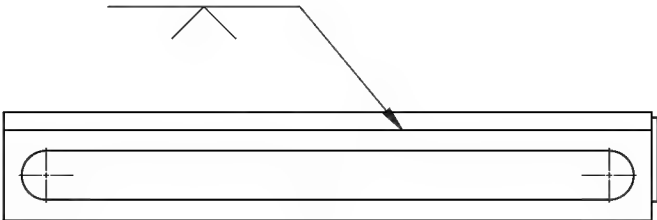
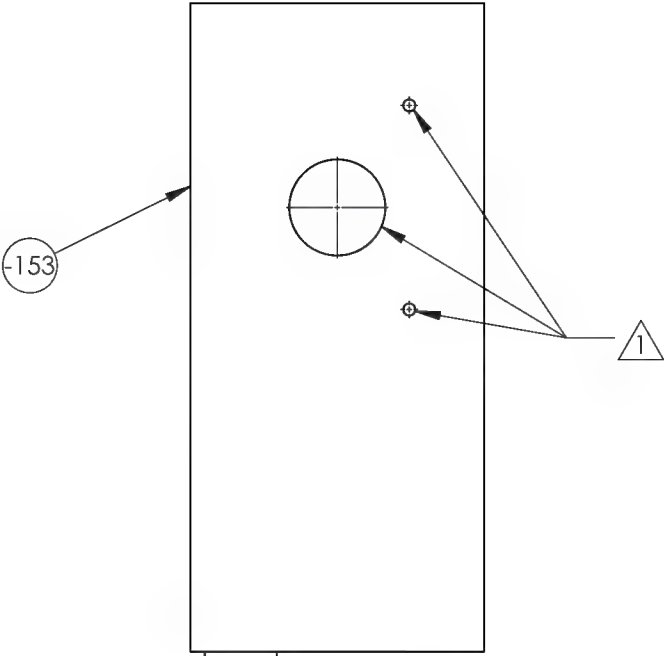
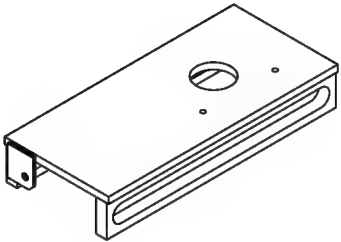
-149

STUD

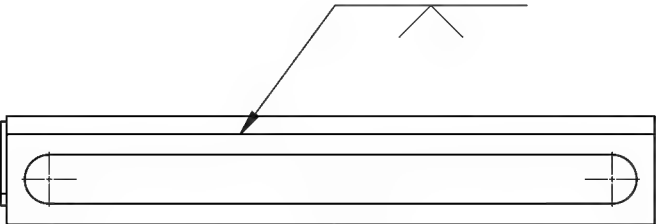
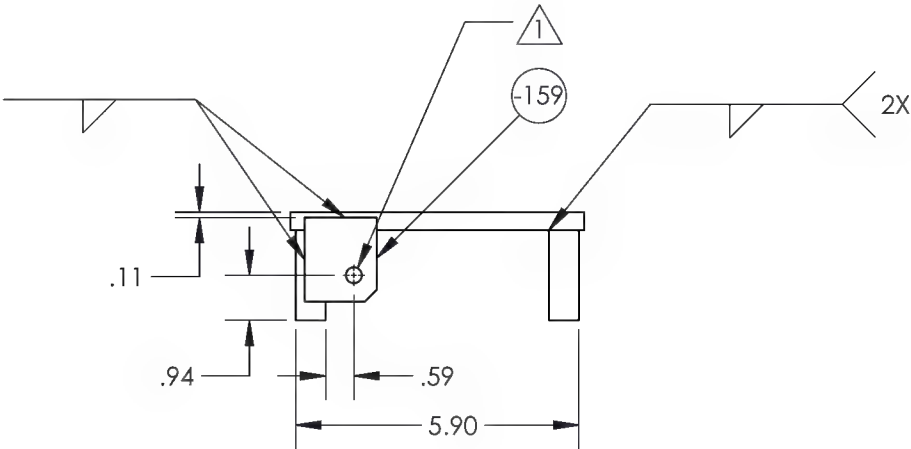
DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-149	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -141 WELDMENT	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 3/13/2014
	SHEET 12 OF 32

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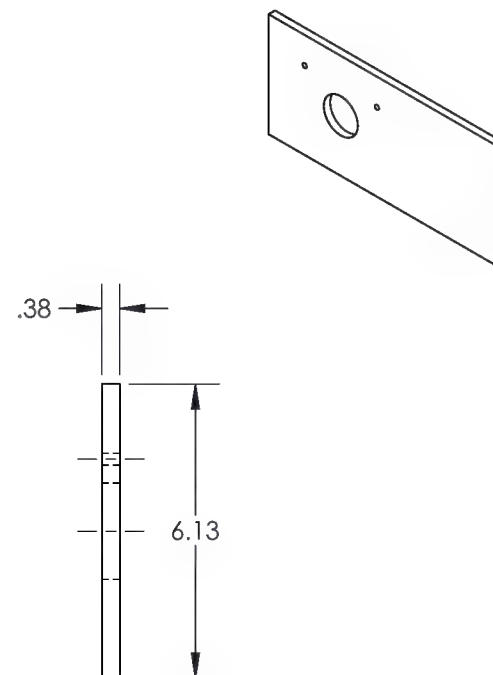
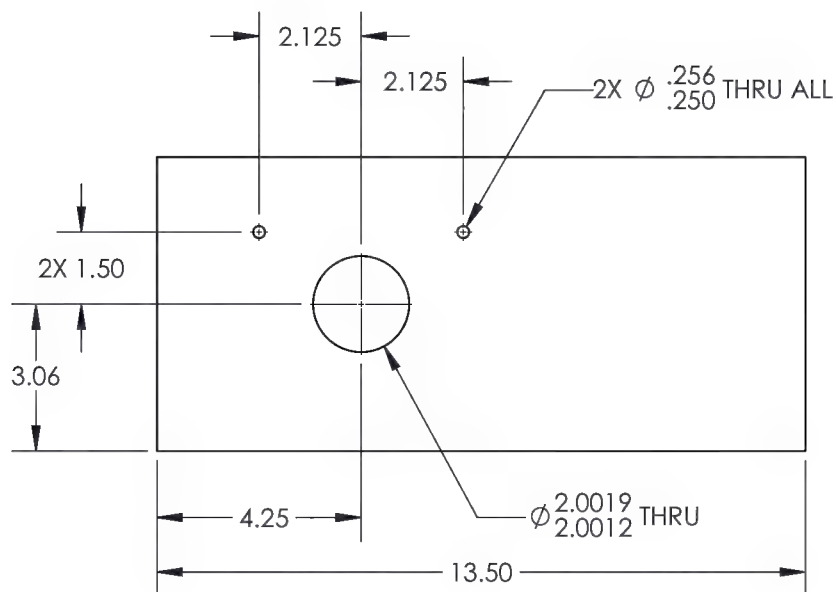
NOTE:
1 NO POWDER COAT IN HOLES.

-151
SLIDE WELDMENT

			
TITLE SUPPORT DOLLY, TAILBOOM			
DWG NO. RB T102012-151			REV 1
MATERIAL HEAT TREAT FINISH POWDER COAT YELLOW SPEC FED #13538		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ±1° .X ± .1 SURFACES = 125✓	
DRAWN BY: GILBERT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: CLOUGH		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT		BELL 212, 214B, 214ST, 412	
SCALE 1:4	DATE 3/13/2014	SHEET 13 OF 32	

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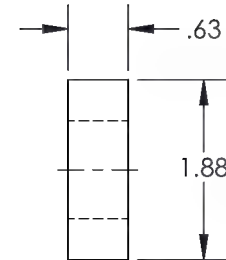
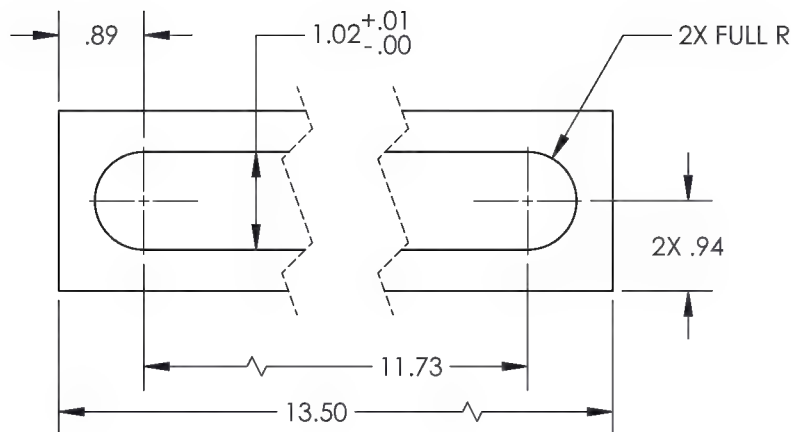
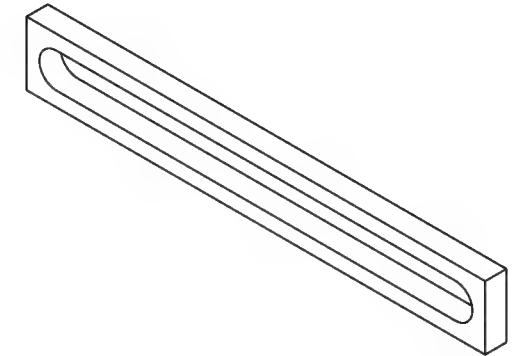
-153

SLIDE TOP

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-153	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -151 WELDMENT	.XXX \pm .010 FRACTIONS \pm 1/8
SPEC	.XX \pm .03 ANGLES \pm 1°
DRAWN BY: GILBERT	.X \pm .1 SURFACES = 125°
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:4	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 3/13/2014	USED ON MODEL
SHEET 14 OF 32	BELL 212, 214B, 214ST, 412

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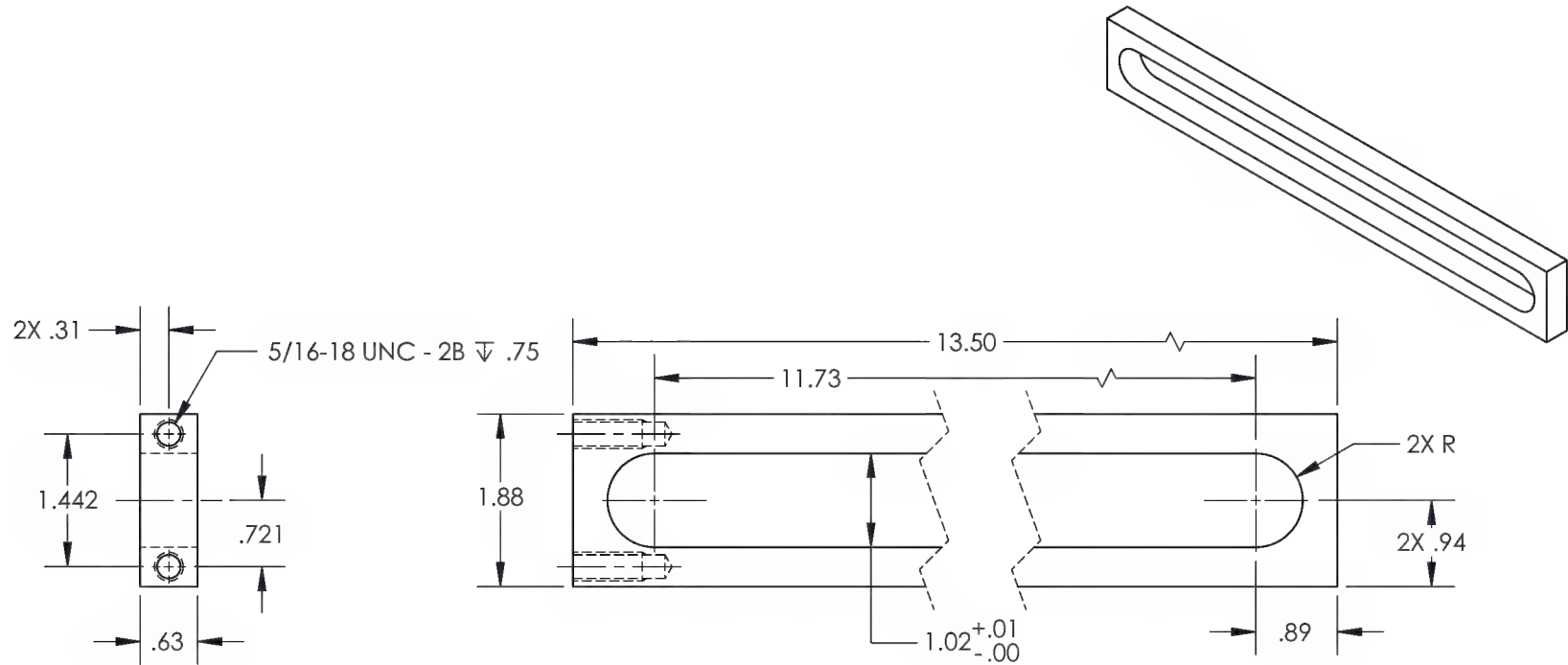
-155

SLIDE SIDE

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-155	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT SEE -151 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -151 WELDMENT	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	BELL 212, 214B, 214ST, 412
SCALE 1:2	DATE 3/13/2014
SHEET 15 OF 32	

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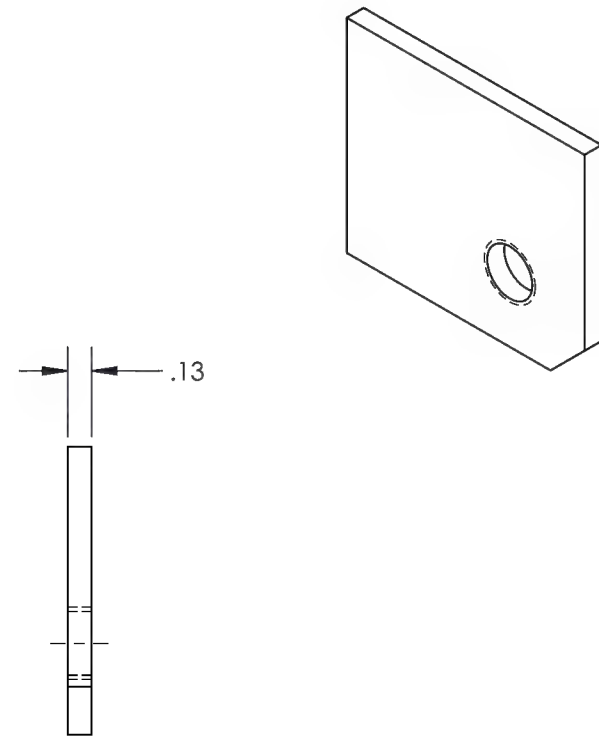
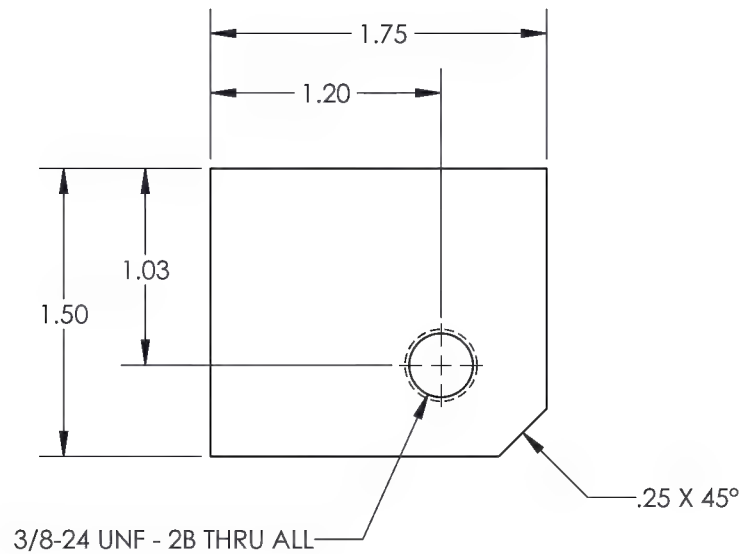
-157

SLIDE SIDE-BOLTED

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-157	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT SEE -151 WELDMENT	DIMENSIONS ARE IN INCHES
FINISH SEE -151 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 3/13/2014
	SHEET 16 OF 32

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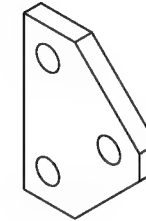
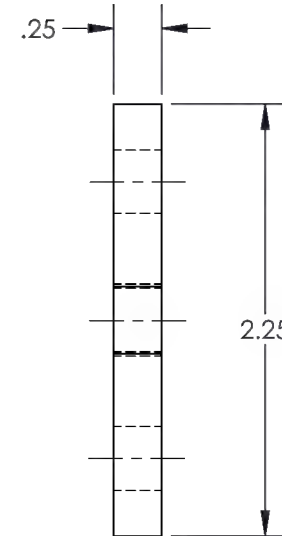
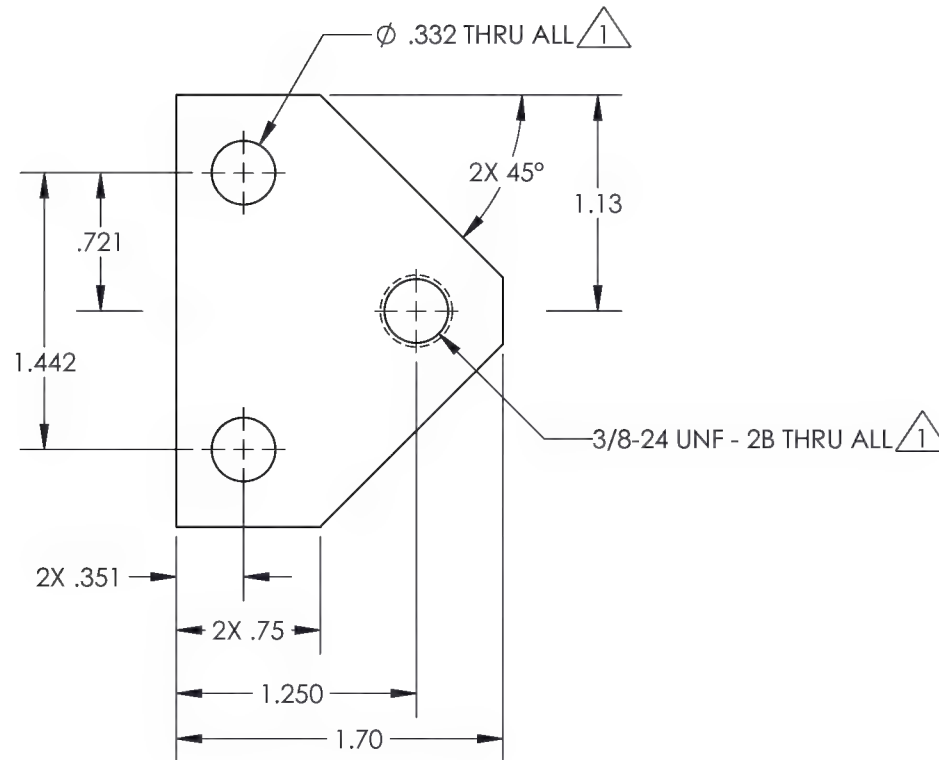
-159

SLIDE SPRING ROD SUPPORT

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-159	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -151 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 3/13/2014
	SHEET 17 OF 32

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				APPROVED



NOTE:

1 NO POWDER COAT IN HOLES.

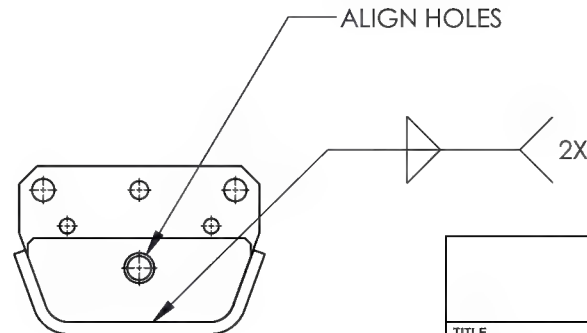
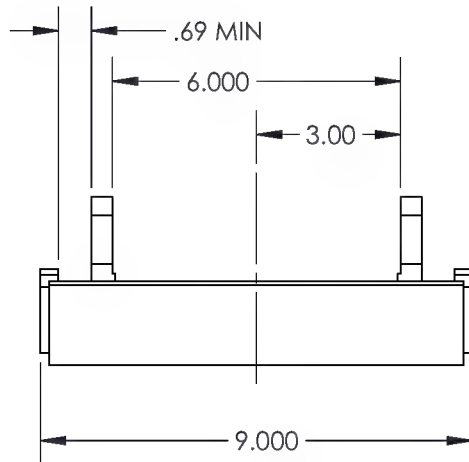
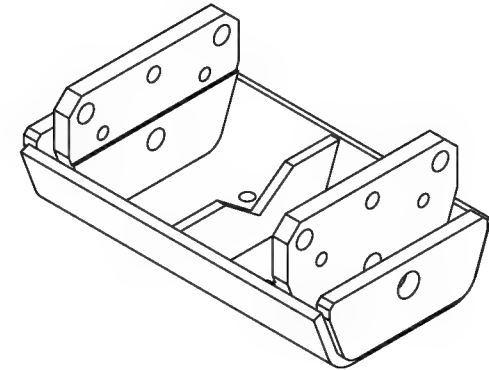
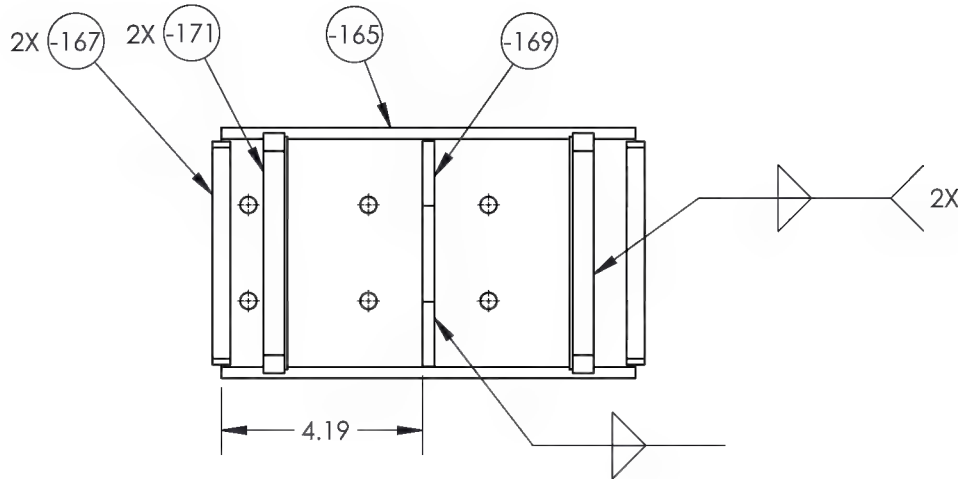
-161

SLIDE SPRING ROD SUPPORT, BOLTED

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-161	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH POWDER COAT YELLOW	.XXX ± .010 FRACTIONS ± 1/8
SPEC FED #13538	.XX ± .03 ANGLES ± 1°
DRAWN BY: GILBERT	.X ± .1 SURFACES = 125
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 3/13/2014	USED ON MODEL
SHEET 18 OF 32	BELL 212, 214B, 214ST, 412

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				APPROVED

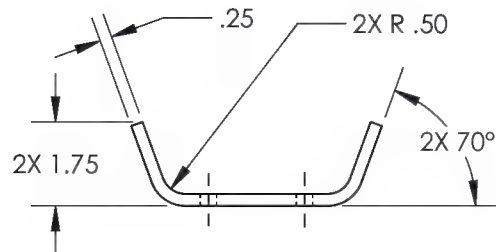
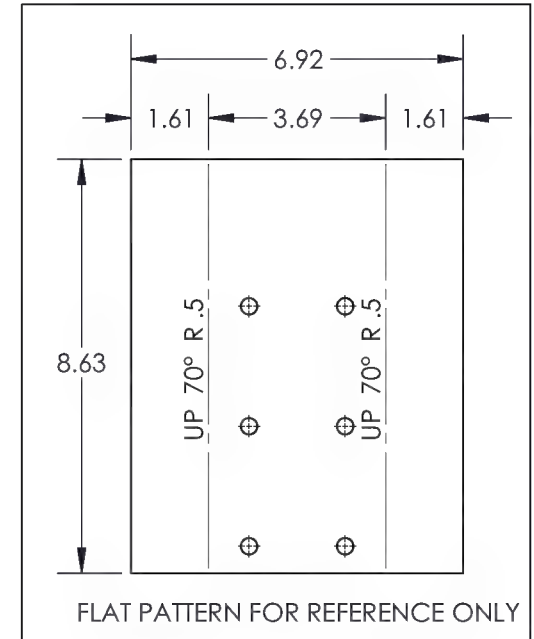
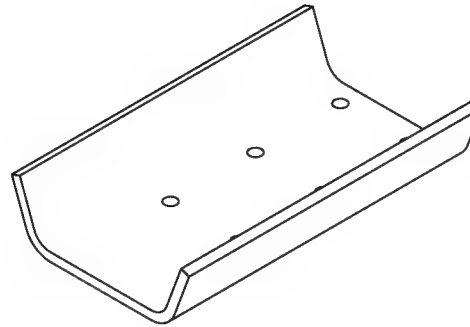
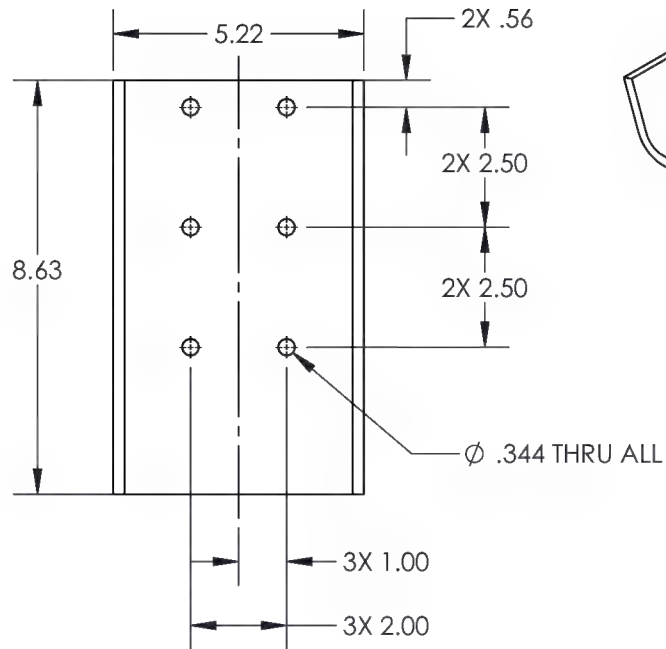


-163
CUP WELDMENT

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-163	REV 1
MAT'L 6061-T6	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TREAT POWDER COAT YELLOW	.XXX ± .010 FRACTIONS ± 1/8
FINISH POWDER COAT YELLOW	.XX ± .03 ANGLES ± 1°
SPEC FED #13538	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	BELL 212, 214B, 214ST, 412
SCALE 1:4	DATE 3/13/2014
SHEET 19 OF 32	

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				APPROVED

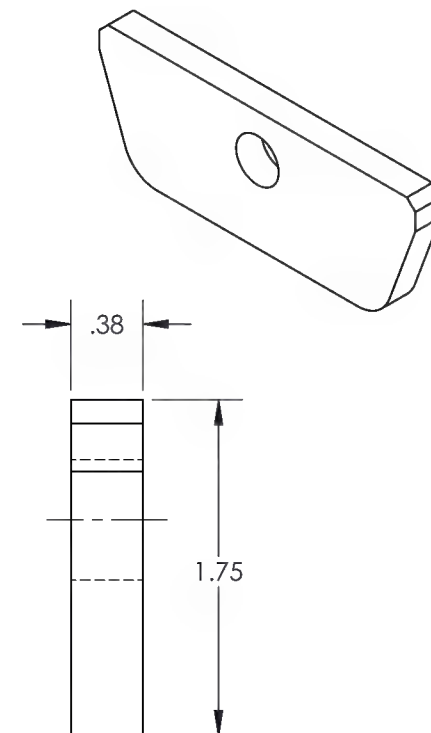
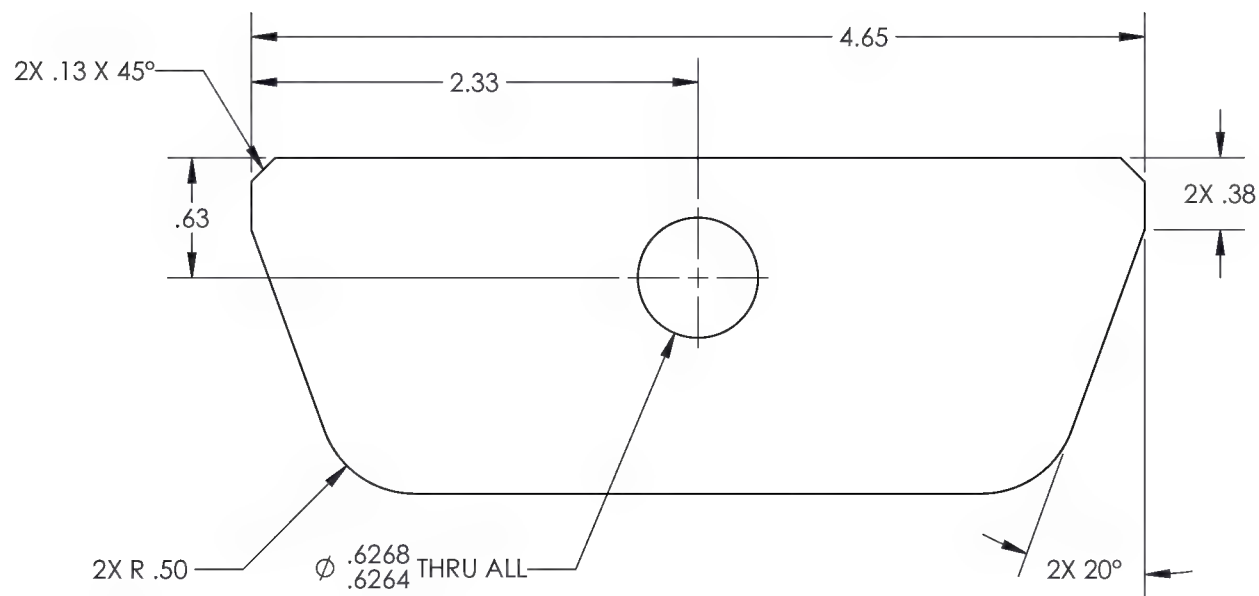


-165
CUP

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-165	REV 1
MAT'L 1018/1020 CR HEAT TREAT FINISH SEE -163 WELDMENT SPEC DRAWN BY: GILBERT CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125✓ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL BELL 212, 214B, 214ST, 412	
SCALE 1:4	DATE 3/13/2014
SHEET 20 OF 32	

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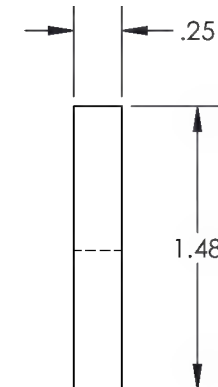
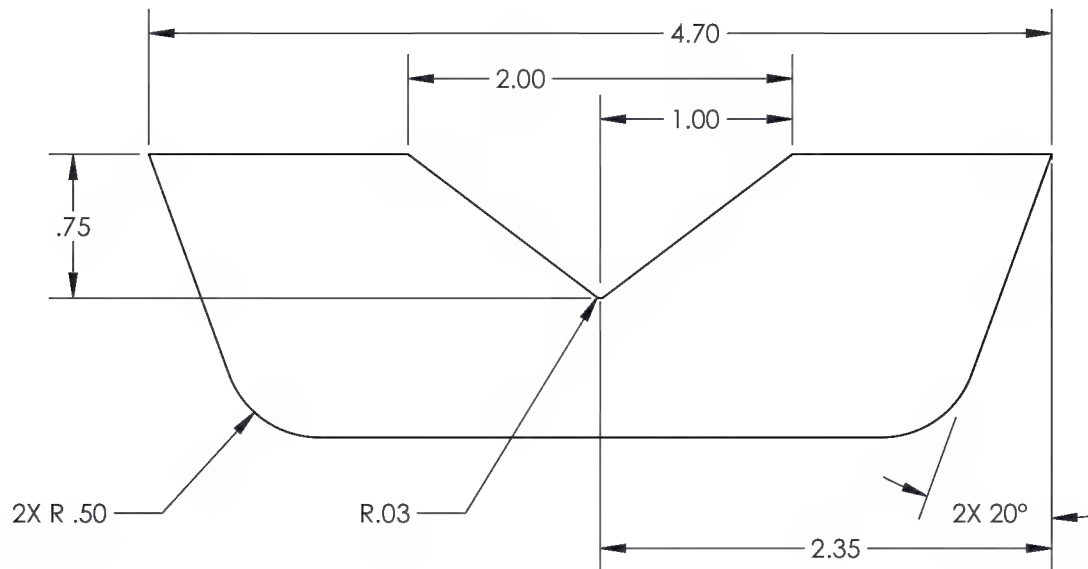
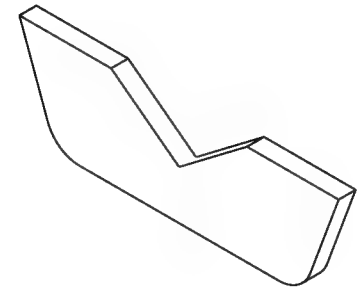


(-167)
CUP, END

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-167	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -163 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 3/13/2014
	SHEET 21 OF 32

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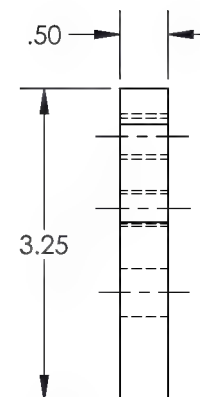
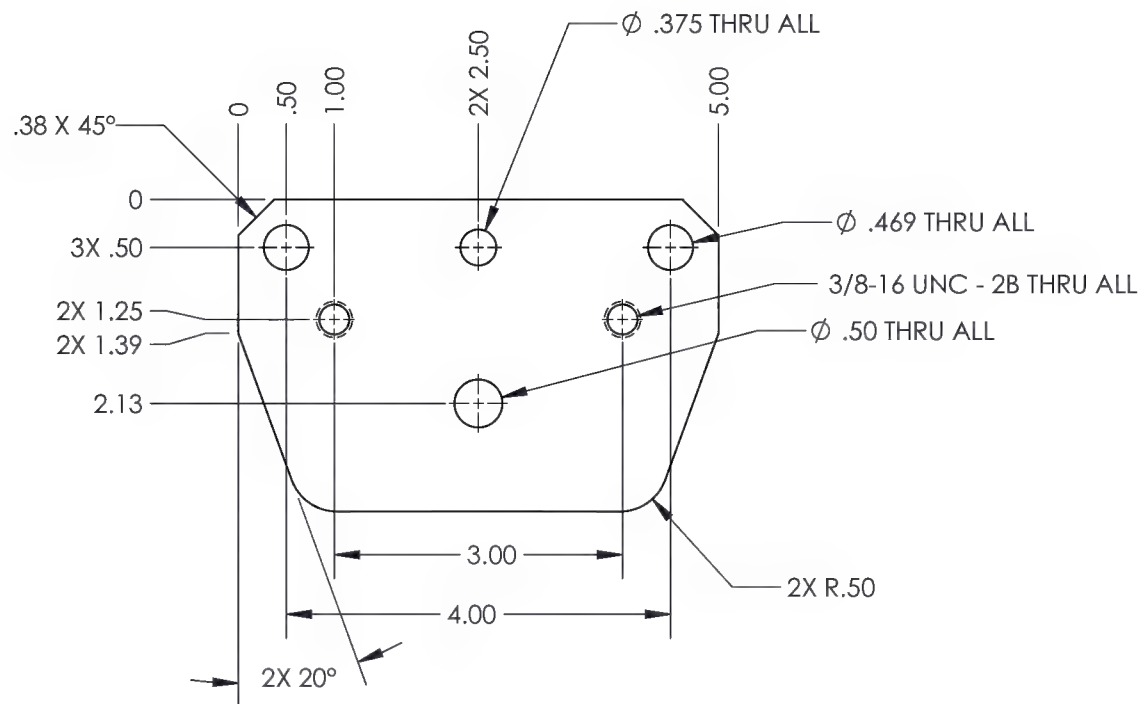
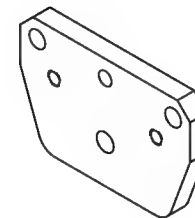
CUP CENTER



TITLE		SUPPORT DOLLY, TAILBOOM	
DWG NO.		RB T102012-169	
REV		1	
MAT'L A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED	
TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -163 WELDMENT		.XXX ± .010 FRACTIONS ± 1/8	
SPEC		.XX ± .03 ANGLES ± 1°	
DRAWN BY: GILBERT		.X ± .1 SURFACES = 125°	
CHECKED: CLOUGH		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT		AFTER PLATING	
SCALE 1:1		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 3/13/2014		USED ON MODEL	
SHEET 22 OF 32		BELL 212, 214B, 214ST, 412	

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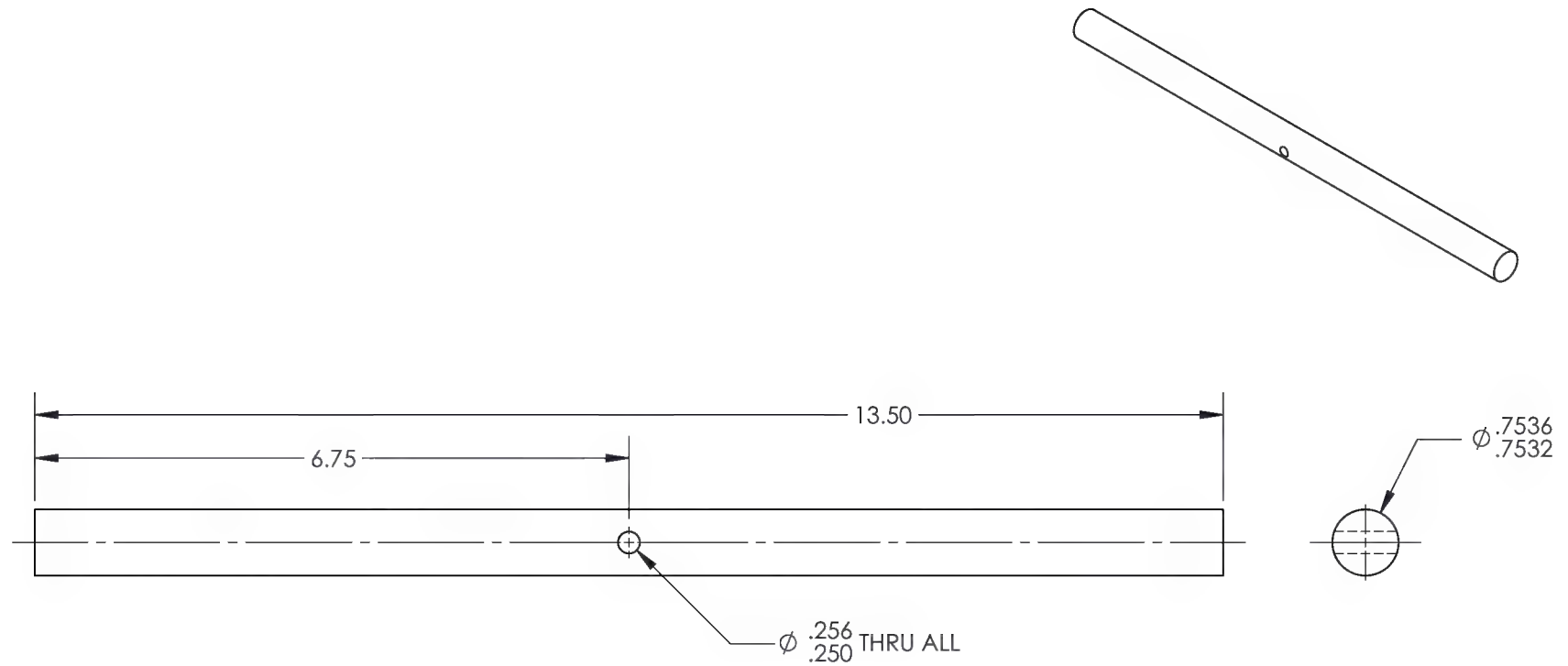


(-171)
CUP, MID

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-171	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT SEE -163 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -163 WELDMENT	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	BELL 212, 214B, 214ST, 412
SCALE 1:2	DATE 3/13/2014
SHEET 23 OF 32	

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				APPROVED



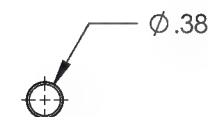
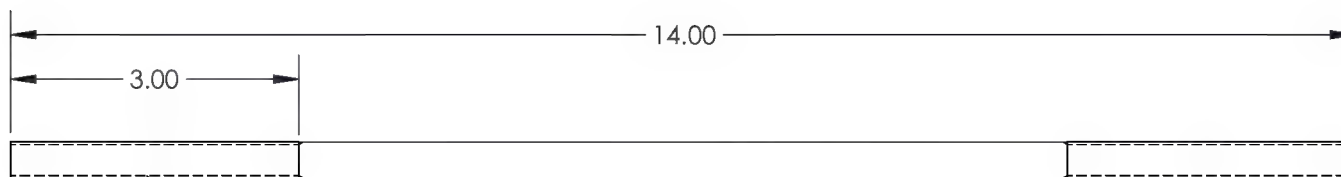
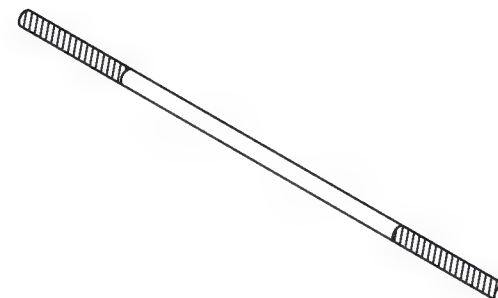
(-173)

CRADLE ROD

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-173	REV 1
MAT'L 4140 G&P	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX \pm .005 FRACTIONS \pm 1/8
SPEC ASTM B633 TYPE I SC 2	.XX \pm .01 ANGLES \pm 5°
DRAWN BY: GILBERT	.X \pm .1 SURFACES = 125°
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:2	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 3/13/2014	USED ON MODEL
SHEET 24 OF 32	BELL 212, 214B, 214ST, 412

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2X 3/8-24 - 2A

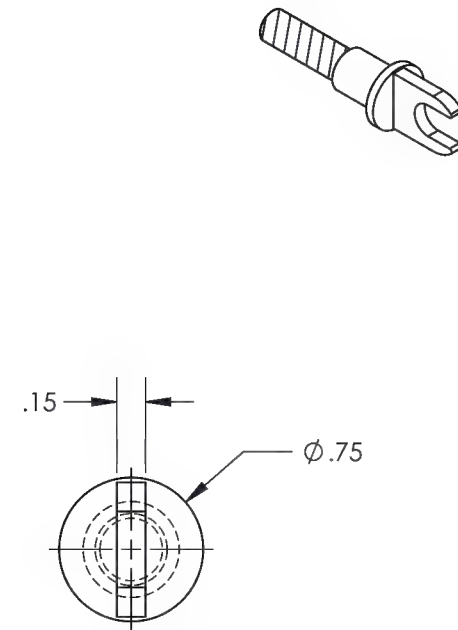
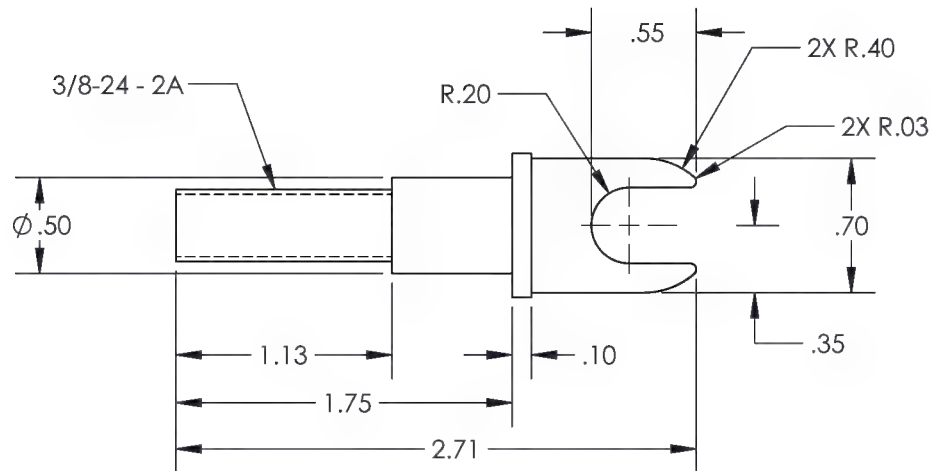
-175

SPRING ROD

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-175	REV 1
MAT'L 303 S.S.	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 3/13/2014
	SHEET 25 OF 32

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				APPROVED



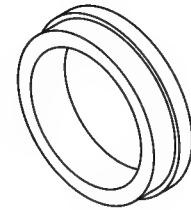
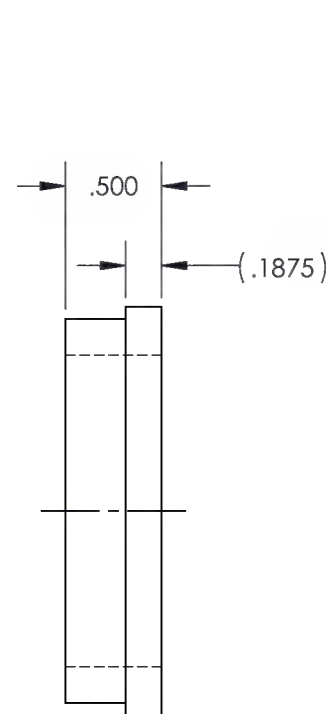
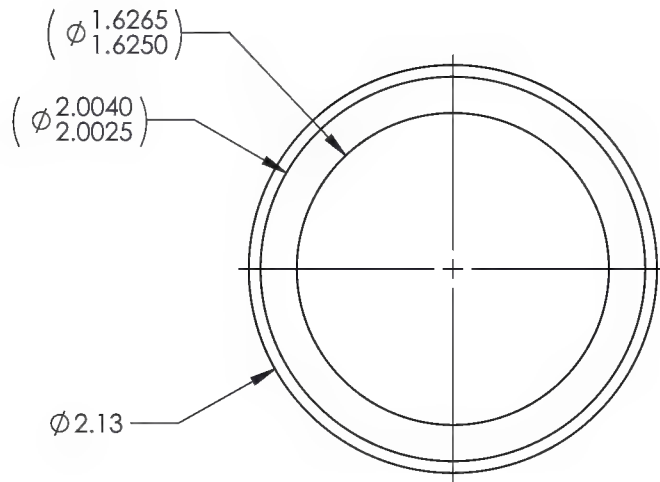
(-177)

ROD SUPPORT

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-177	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: GILBERT	.X ± .1 SURFACES = 125°
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 3/13/2014	USED ON MODEL
SHEET 26 OF 32	BELL 212, 214B, 214ST, 412

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



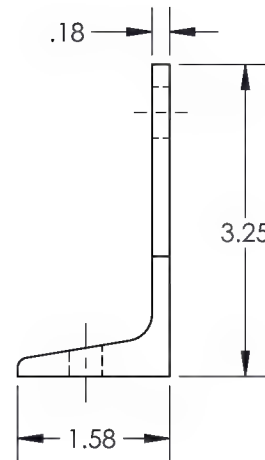
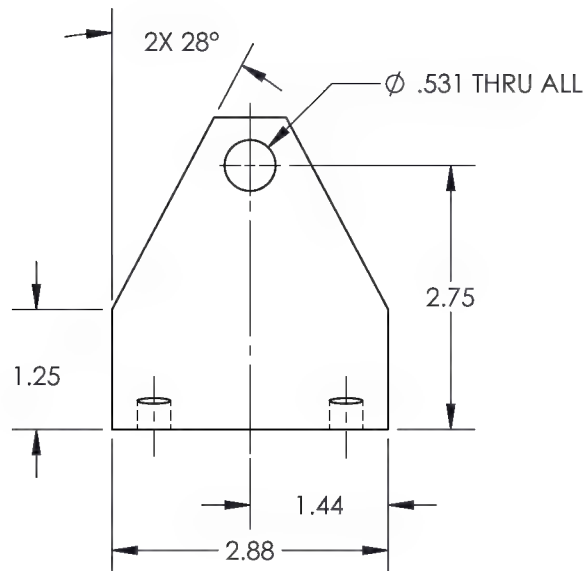
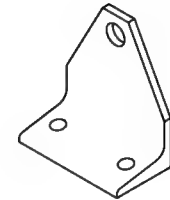
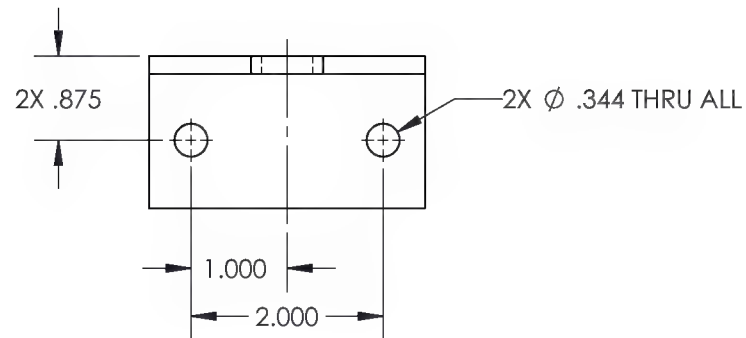
(-179)

FLANGE BEARING

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-179	REV 1
MAT'L BRONZE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 3/13/2014
	SHEET 27 OF 32

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				APPROVED



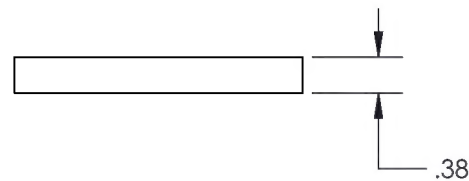
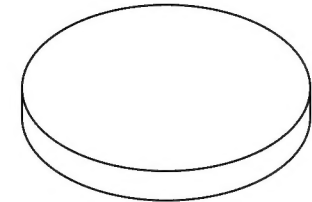
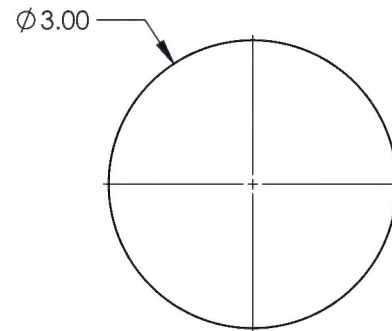
(-181)

PIVOT BRACKET

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-181	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH POWDER COAT YELLOW	.XXX ± .010 FRACTIONS ± 1/8
SPEC FED #13538	.XX ± .03 ANGLES ± 1°
DRAWN BY: GILBERT	.X ± .1 SURFACES = 125° ✓
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: GILBERT	USED ON MODEL
SCALE 1:2	BELL 212, 214B, 214ST, 412
DATE 3/13/2014	SHEET 28 OF 32

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				APPROVED



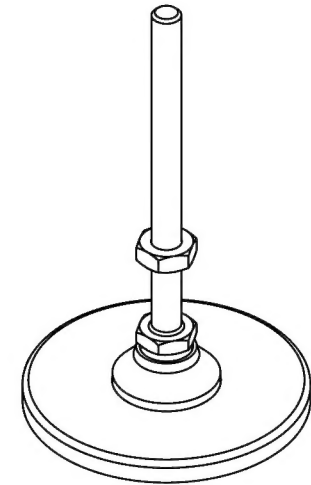
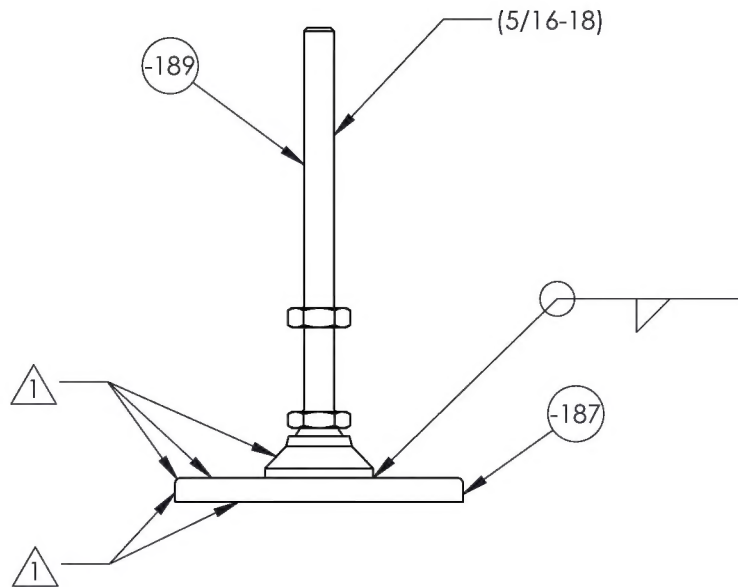
-183

RUBBER PAD

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-183	REV 1
MAT'L RUBBER	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE	USED ON MODEL
1:2	BELL 212, 214B, 214ST, 412
DATE	
7/13/2016	
SHEET	
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				APPROVED



NOTE:

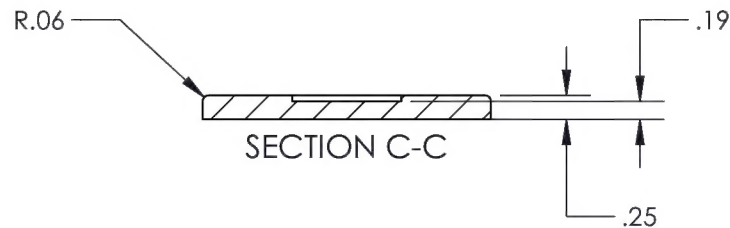
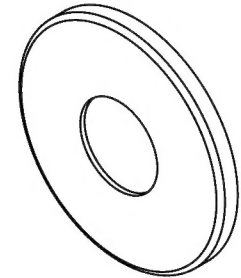
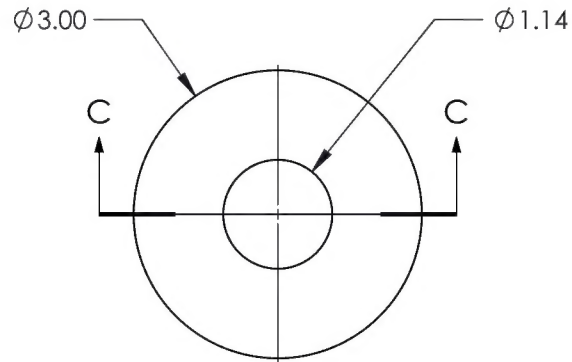
 POWDER COAT YELLOW, SPEC: FED #13538.

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-185	REV 1
MAT'L REPT TREAT FINISH SEE NOTES	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	BELL 212, 214B, 214ST, 412
SCALE 1:2	DATE 7/13/2016
SHEET 30 OF 32	

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REST WELDMENT

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



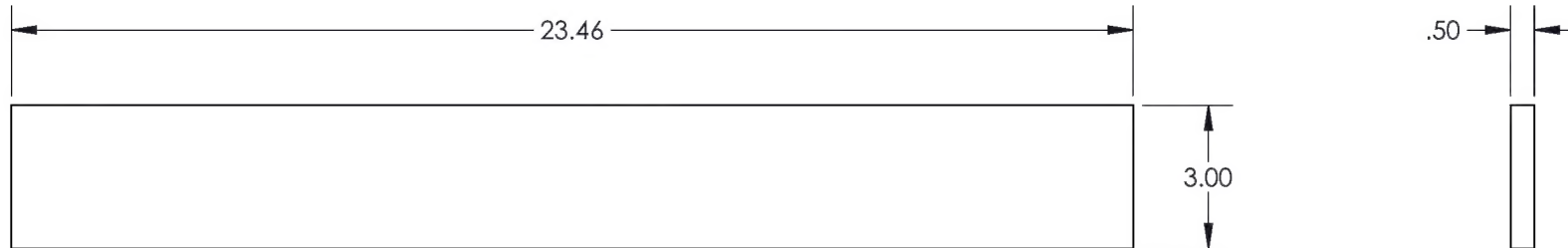
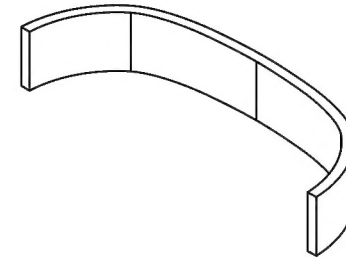
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REST WELDMENT PAD

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-187	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -185 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 7/13/2016
	SHEET 31 OF 32

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



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CRADLE PAD

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-191	REV 1
MAT'L 17124	UNLESS OTHERWISE SPECIFIED
HEAT	DIMENSIONS ARE IN INCHES
TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
SCALE 1:4	ASME Y14.5M-2009
DATE 3/13/2014	USED ON MODEL
SHEET 32 OF 32	BELL 212, 214B, 214ST, 412